

Work Order ID 135549

Wednesday, August 12, 2015 4:03:36 PM

646.3210
B135549
REV. N/C

135549

Page 1

Item ID: 646.3210

Revision ID:

Item Name: Support

Start Date: 8/12/15

Start Qty: 5.00

5

Required Date: 8/12/15

Req'd Qty: 5.00

5

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: AUG 17 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3200

n/c

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 10.35"

5 0 JFC 2015-10-05

110

0.01

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.09

HAAS CNC vertical machine #1

1-Machine per folio FB146

DWG REV: N/C

FOLIO REV: AA

2- deburr and break all sharp edges

5 0 JFC 2015-10-07

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																			
Misidentified ☐	Past Due ☐																				

Work Order ID 135549

Wednesday, August 12, 2015 4:03:36 PM

135549

Page 2

Item ID: 646.3210 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 8/12/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						5	0		Jfe 2015-10-07
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130						5	0		DAS 14 9-89 15/10/08
QC	Memo	0.00							
Quality Control									
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140						CZ	OCT 14 2015	5	
Outsource4	Memo	6.00							
Outsource process - Anodize	Issue P/O to ATG : <u>30121</u>								
	1- Black Anodize as per Dwg 646.3200								
	2- PRIME AS PER DWG, SEE NOTE #2								
	Certification of Comformity is required								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

Work Order ID 135549

Wednesday, August 12, 2015 4:03:36 PM

135549

Page 3

Item ID: 646.3210

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 8/12/15

Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/12/15

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

5 DAS
6
9-89

OCT 23 2014

155

QC5- Inspect part completeness to step on W/O

0.00

155

QC

Memo

0.00

Quality Control

5

DAS
38
9-89

OCT 23 2015

180

Identify as per dwg & Stock Location: 56020

0.00

180

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

5

OCT 26 2014

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 135549***135549***

Page 4

Item ID: 646.3210

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Support

Stop ***NS2***

Start Date: 8/12/15

Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/12/15

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

OCT 23 2015

MCS

20151026
SA

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																							
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Picklist Print

Wednesday, August 12, 2015 4:03:35 PM

Page 1

Work Order ID: 135549

135549

Parent Item: 646.3210

646.3210

Parent Item Name: Support

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 12-11-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B6.000X1.000		Purchased	No				f	123.1880		4.536842			

M7075T6B6 000X1 000

7075-T6 BAR 6.000" X 1.000"

Location

Loc Qty

Loc Code

MAT005

123.188

M129891

9

M130014

90

M131357

24.188

4.536 JFC 2015-10-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

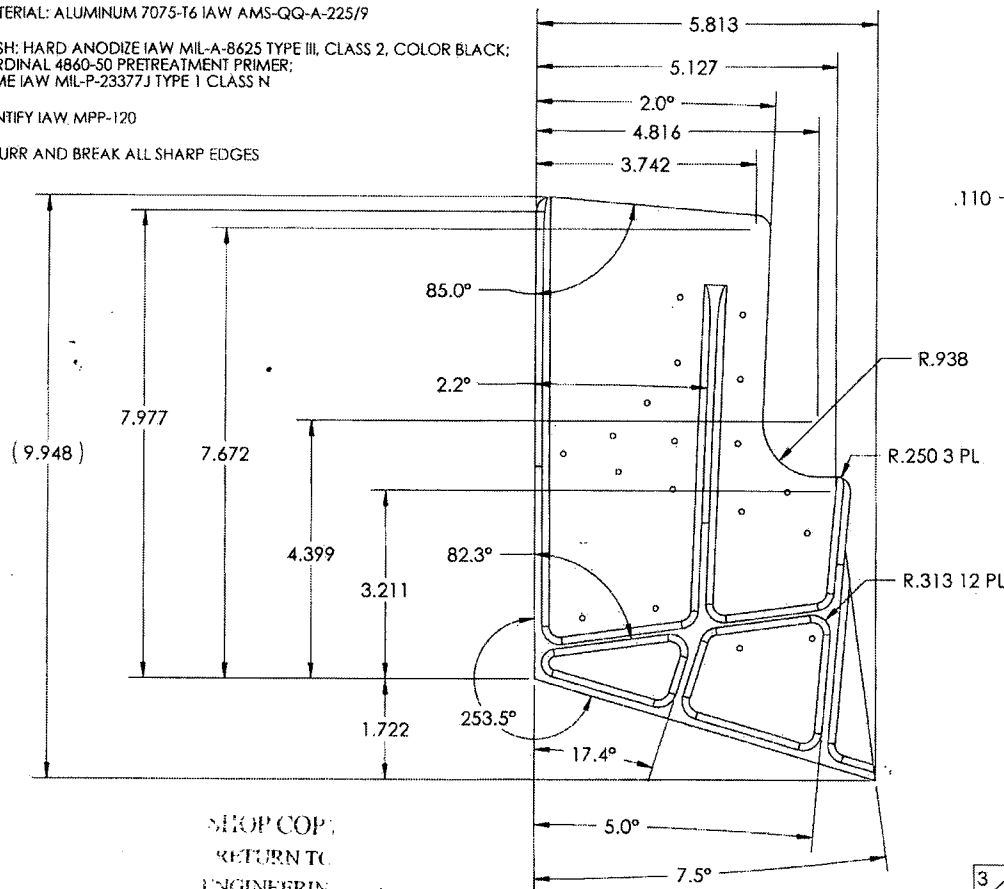
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

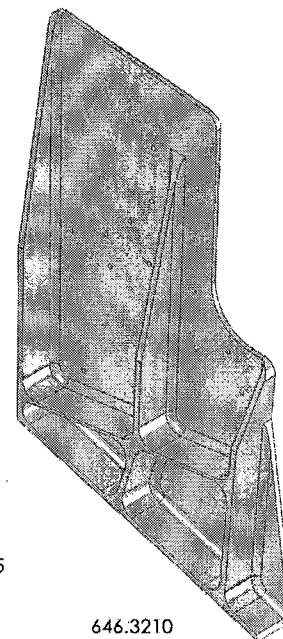
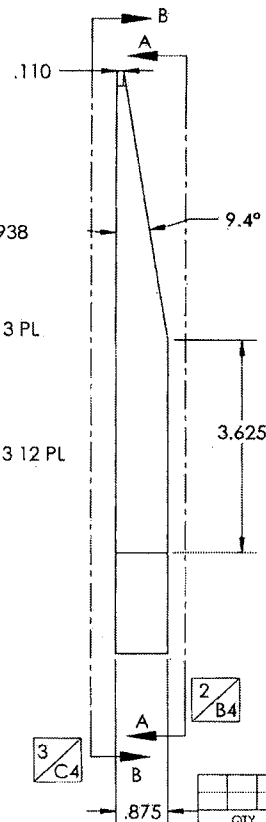
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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T6 IAW AMS-QQ-A-225/9
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER; PRIME IAW MIL-P-23377J TYPE 1 CLASS N
- 3 IDENTIFY IAW MPP-120
- 4 DEBURR AND BREAK ALL SHARP EDGES



STOP COPY
RETURN TO
ENGINEERIN
UNCONTROLLED
SUBJECT TO AMEN
WITHOUT NOT
WORK ORD
NO. 135548_MLS
1508-13



646.3210

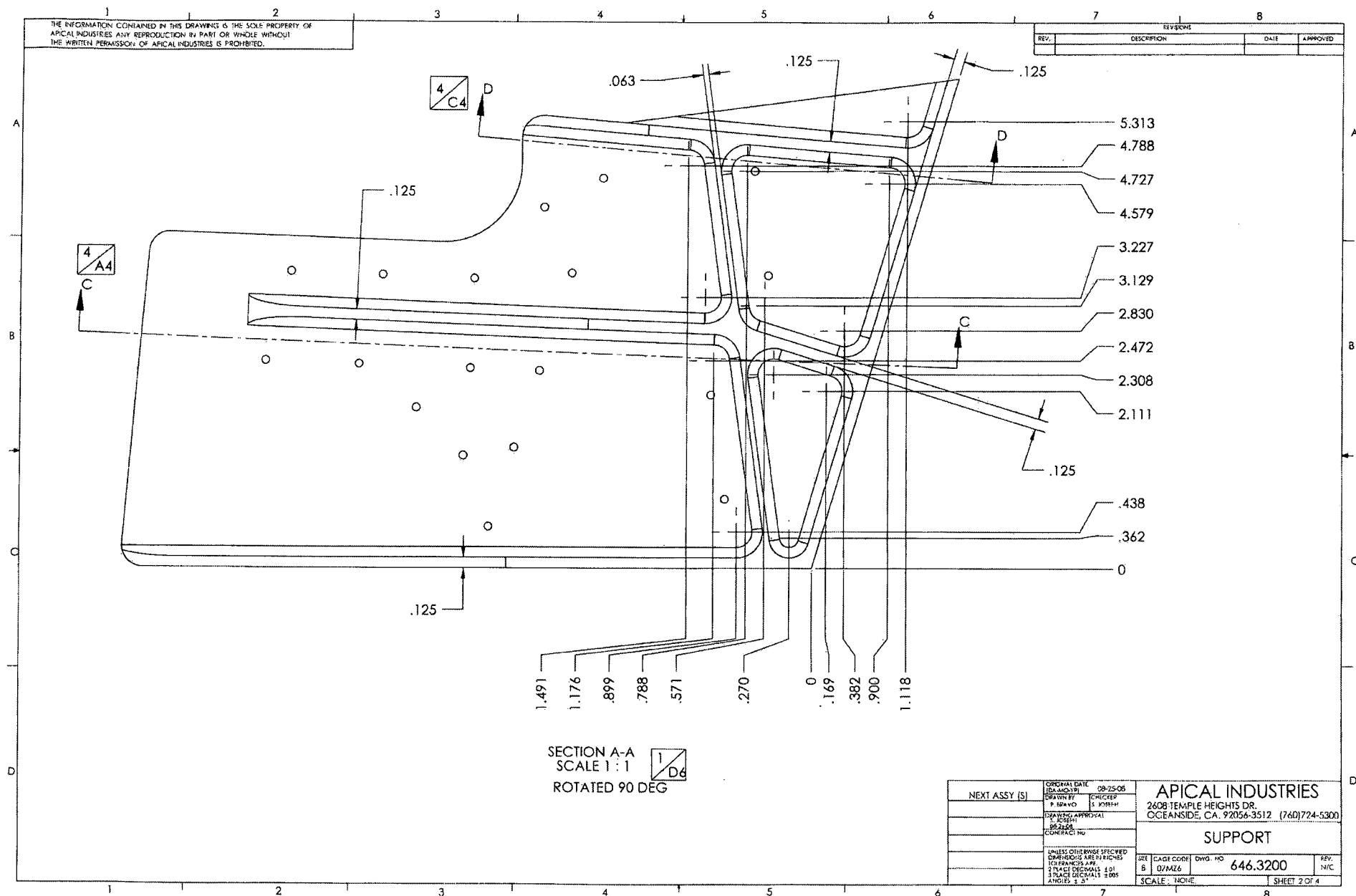
REV.	DESCRIPTION	DATE	APPROVED

QTY	646.3210	SUPPORT	DESCRIPTION	MATL	SPEC.
NEXT ASSY (S)	646.4000	646.3210	646.3210	646.3210	646.3210
ORIGINAL DATE	08-25-08	DESIGNED BY	P. BRAVO	CHECKED BY	S. JOSEPH
DRAWING APPROVAL		DESIGNED BY	P. BRAVO	CHECKED BY	S. JOSEPH
CONTRACT NO.		DESIGNED BY	P. BRAVO	CHECKED BY	S. JOSEPH
UNLESS OTHERWISE SPECIFIED		DESIGNED BY	P. BRAVO	CHECKED BY	S. JOSEPH
DIMENSIONS ARE IN INCHES		DESIGNED BY	P. BRAVO	CHECKED BY	S. JOSEPH
TOLERANCES ARE		DESIGNED BY	P. BRAVO	CHECKED BY	S. JOSEPH
PLACES DECIMALS 201		DESIGNED BY	P. BRAVO	CHECKED BY	S. JOSEPH
SPRINGS DECIMALS 1005		DESIGNED BY	P. BRAVO	CHECKED BY	S. JOSEPH
ANGLES 2 3		DESIGNED BY	P. BRAVO	CHECKED BY	S. JOSEPH

APICAL INDUSTRIES	2608 TEMPLE HEIGHTS DR.	OCEANSIDE, CA. 92056-3512	(760) 724-5300
SUPPORT	646.3210	REV. N/C	SCALE: NONE
SHEET 1 OF 4			

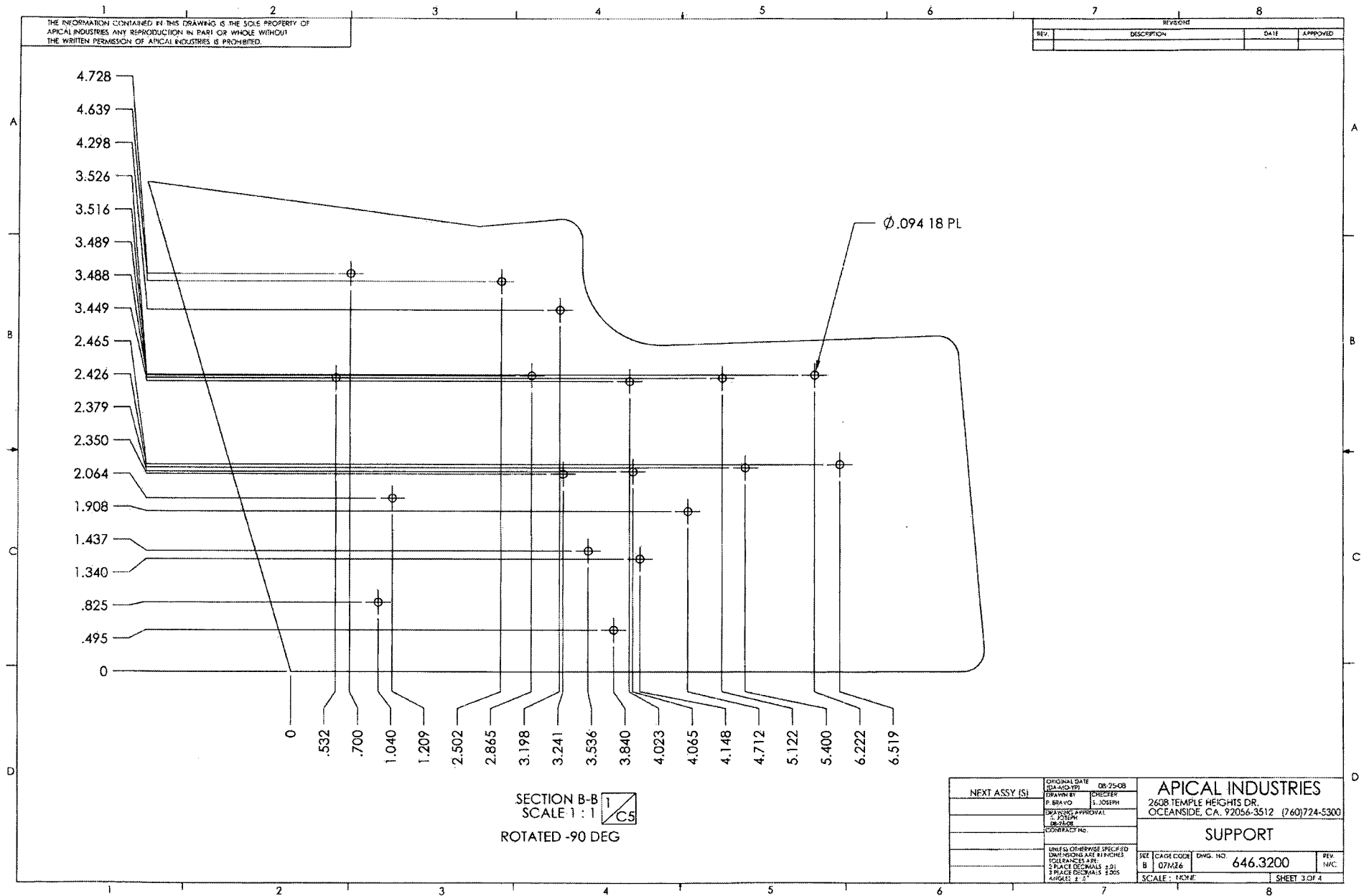
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



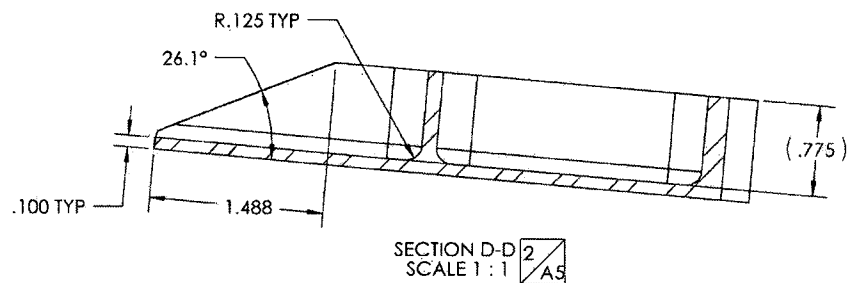
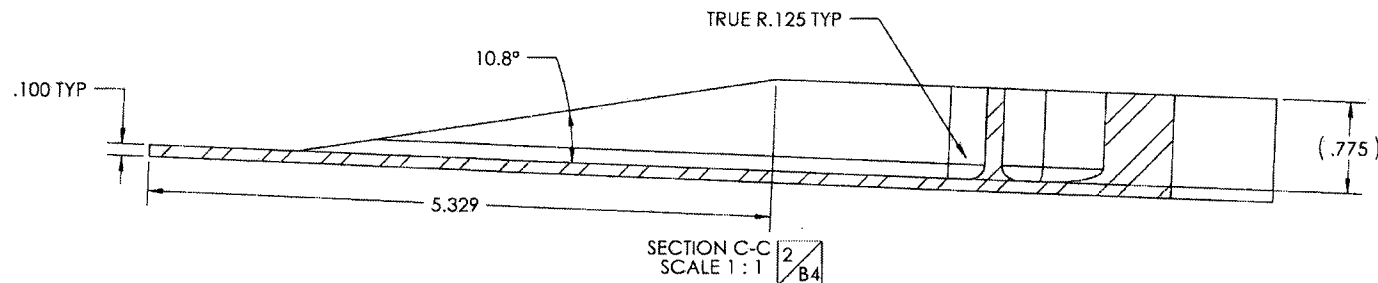
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REVISION			
REV.	DESCRIPTION	DATE	APPROVED



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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



NEXT ASSY (S)	OFFICIAL DATE (DATE)	08-25-08
	DRAWN BY	P. BRAYO
	CHECKED BY	S. JOSEPH
	DESIGNED BY	S. JOSEPH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°	APICAL INDUSTRIES	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
	SUPPORT	
	REV	8
	CAGE CODE	646.3200
	DWG NO.	646.3200
	SCALE	NONE
	SHEET 4 OF 4	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 63965

Date: 22-Oct-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
10 ea	Part: D4726-1 HANDLE HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20150766	Rev: A PO: PO30121	Line:
5 ea	Part: 646.3210 SUPPORT HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150767	Rev: N/C PO: PO30121	Line: <i>15/10/23</i>
4 ea	Part: 646.3311 RH HALF HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150768	Rev: N/C PO: PO30121	Line:
6 ea	Part: 647.0113 STRUT DOUBLER HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150769	Rev: PO: PO30121	Line:
2 ea	Part: 647.0410 TUBE REV HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2	Rev:	Line:



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731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
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Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

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DART AEROSPACE LTD
1270 ABERDEEN ST.
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Canada

Ph: 613-632-5200

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Fax: 613-632-1185

Terms	Ship Via				
<table border="1"><thead><tr><th>Quantity</th><th>Description</th></tr></thead><tbody><tr><td></td><td> Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>22/10/15</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____ </td></tr></tbody></table>		Quantity	Description		Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>22/10/15</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____
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